

Date: Thursday, 3/1/2007 11:34:17 AM  
 User: Kim Johnston

## Process Sheet

SPLIT-

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG ASSEMBLY  
 Job Number : 30998  
 Estimate Number : 11745  
 P.O. Number : *N/A* Part Number : D3394043  
 This Issue : 3/1/2007 S.O. No. : *N/A* Drawing Number : D3394 REV A  
 Prsht Rev. : *NC* Project Number : *N/A*  
 First Issue : *N/A* Type : MACHINED PARTS Drawing Revision : *A*  
 Previous Run : 30907 Material : *N/A*  
 Written By : *[Signature]* Due Date : 12/3/2007 Qty: *50* Um: Each  
 Checked & Approved By : *[Signature]*  
 Comment : Est Rev: *A* New Issue 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0735 f(s)/Unit Total : 14.7000 f(s)  
 D2423 Lug Extrusion  
 Batch: *30062*

2.0 BAND SAW BAND SAW



Comment: BAND SAW  
 Cut Blank to .850"

3.0 OUTSIDE SERVICE OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES  
 Send Blanks To: Metec/Mast Precision Machining  
 P/O: *BLKT 00001* *C 207/03/08* *(500)* *50*  
 Machine D3394-3 as per Dwg D3394

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
 Receive & Inspect For Transit Damage

5.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

*[Signature]* *207/06/12* *(50)*  
*207/06/13* *(50)*  
*reintert*





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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 30998

Part Number: D3394043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

42 07-06-14 (50)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR / FL 07/06/19 (42) P10

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 07/06/20 (42X)

9.0

MS3548993

GROMMET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 400.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS35489-93 Grommet M103688

MF 07-06-21 (84)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3394

MF 07-06-21 (42)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP / 07-06-21

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/06/25 (42)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/25 (42)

Job Completion



U 07-06-25



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07-06-15	7	split to send 8 to outside supplier for priority	LL	07-06-15	8	LL		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/06/25  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

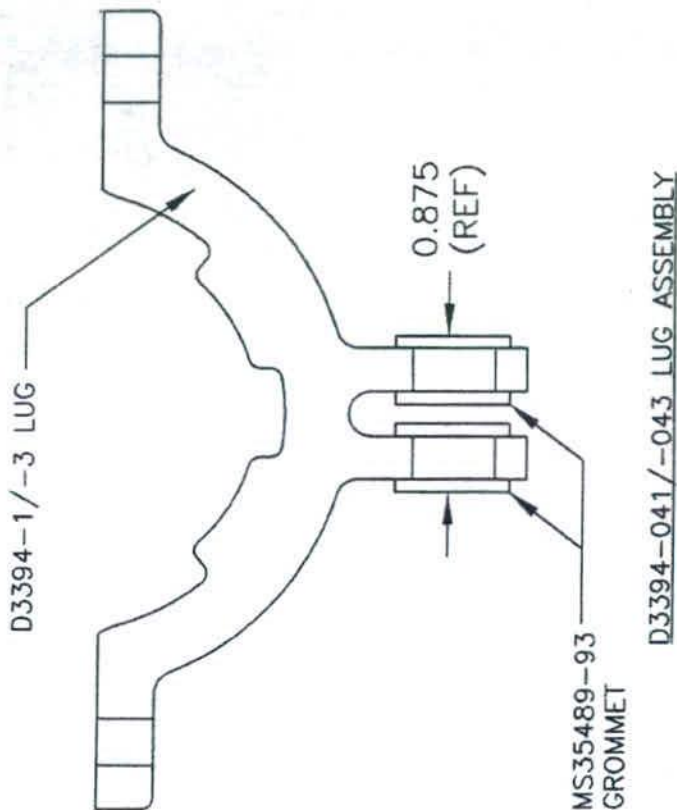
NOTE: Date & initial all entries





**DART**

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3394	REV. A SHEET 1 OF 3
DATE 05.02.14		TITLE LUG	SCALE 1:1
A	05.02.14	NEW ISSUE	

**PARTS LIST FOR D3394-041/-043 LUG ASSEMBLY**

QTY -		PART NUMBER	DESCRIPTION
041	043		
X		D3394-041	LUG ASSEMBLY
	X	D3394-043	LUG ASSEMBLY
1		D3394-1	LUG
	1	D3394-3	LUG
2	2	MS35489-93	GROMMET

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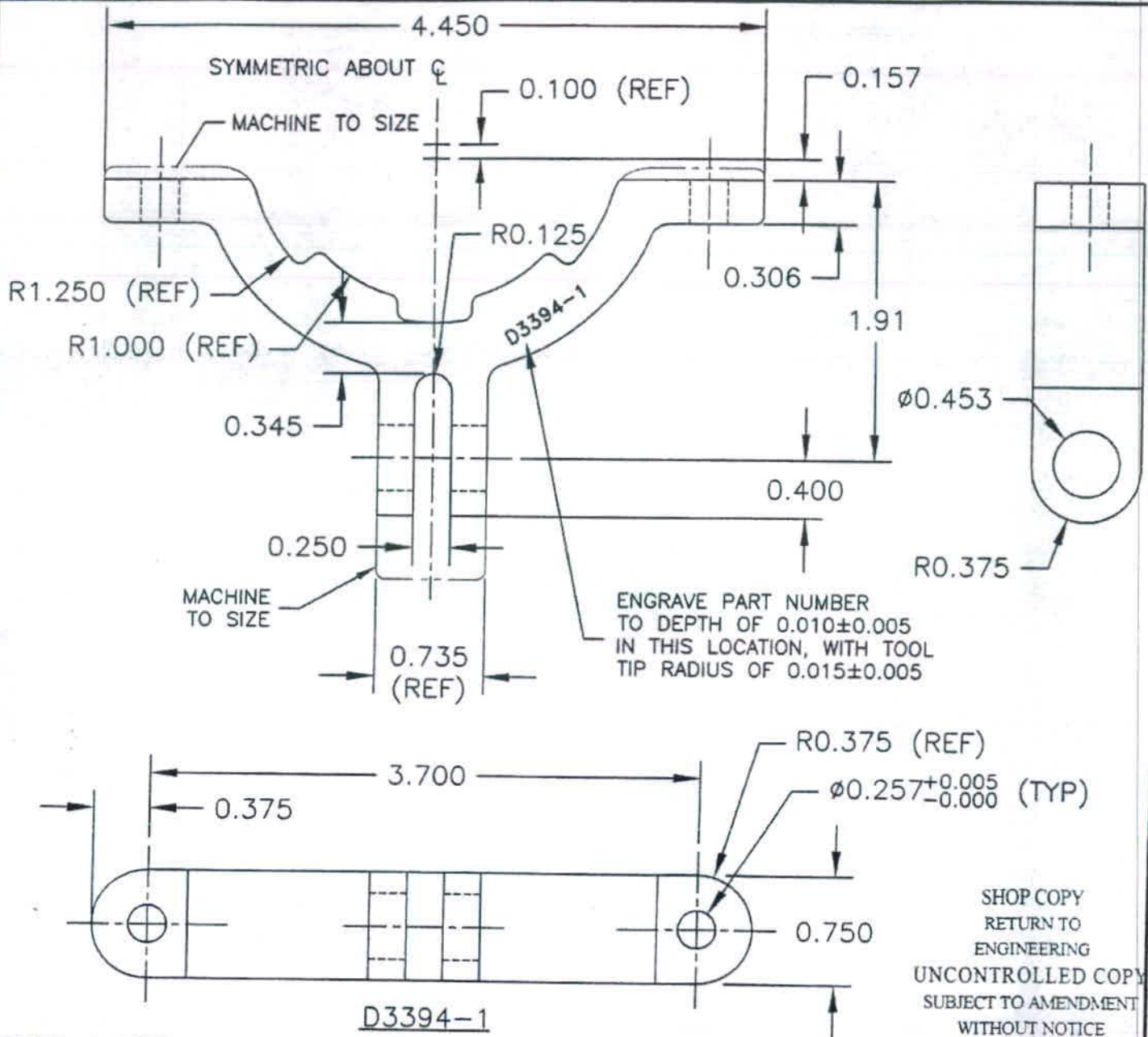
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CHECKED #	APPROVED #	DRAWING NO. D3394	REV. A SHEET 2 OF 3
DATE 05.02.14		TITLE LUG	SCALE 1:1

**D3394-1 NOTES**

- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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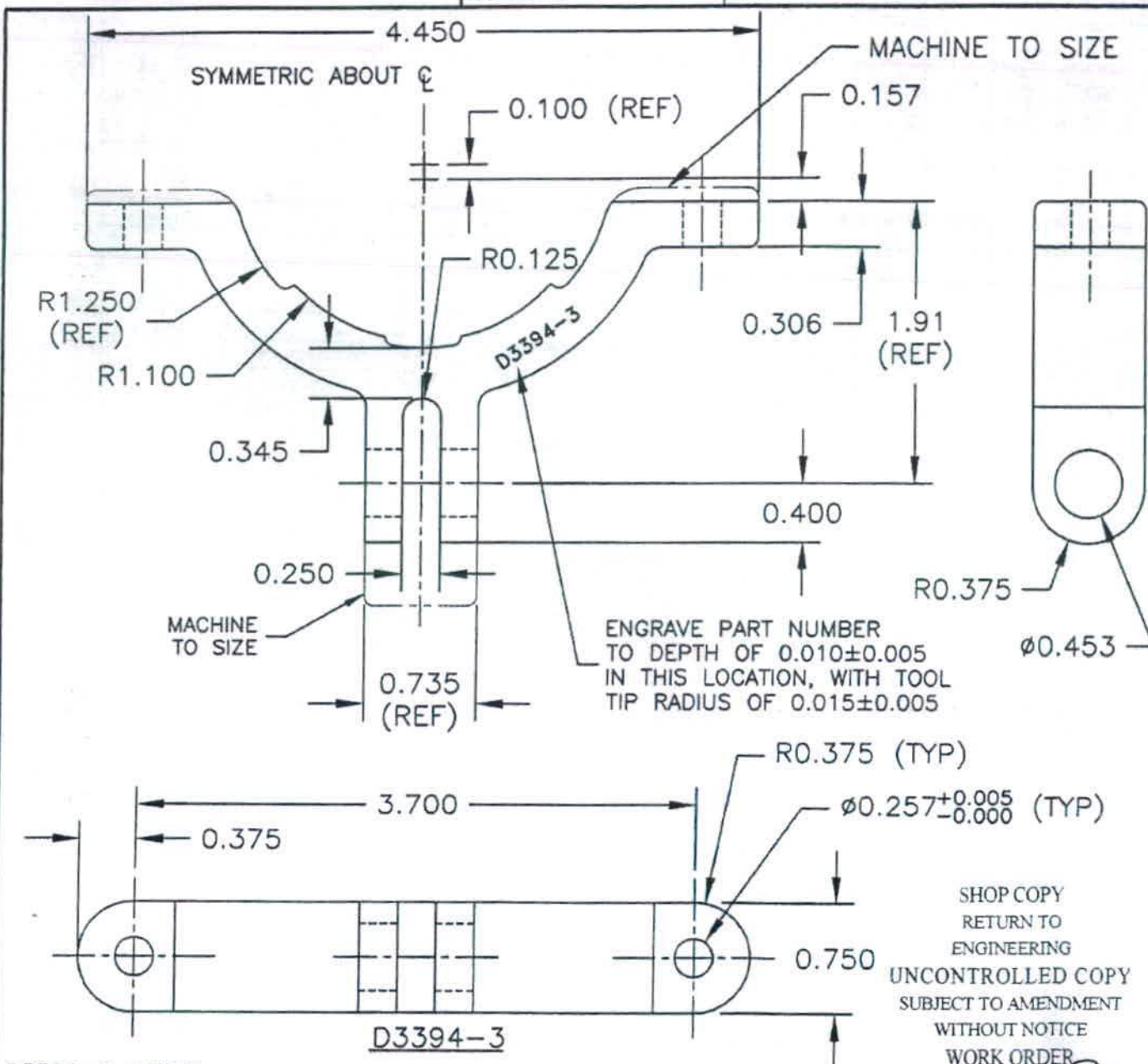
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<i>[Signature]</i>	<i>[Signature]</i>	D3394	SHEET 3 OF 3
DATE	TITLE	SCALE	
05.02.14	LUG	1:1	

**D3394-3 NOTES**

- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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### CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
30	D2230-3	Lug B30993	BLKT00001
50	D2731-3	Lug B30994	BLKT00001
50	D2731-7	Lug B30995	BLKT00001
150	D3235-1	Lug B30996	BLKT00001
50	D3394-1	Lug B30997	BLKT00001
50	D3394-3	Lug B30998	BLKT00001

MATERIAL: supplied by DART D2423 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.



Shigi (Regula) Walz

Vankleek Hill, June 12, 2007

